

## Abstract

Manufacturing process for a cooling channel piston with formable shoulder Process for manufacturing a cooling channel piston which has a cooling channel approximately in the area behind the ring belt, where a piston blank is shaped at least partially by forging, where in accordance with the invention it is envisaged that a circumferential shoulder is formed in the area of the heat dam also by forging, a recess is introduced behind the shoulder and the shoulder is subsequently reshaped by deformation in such a way that the recess is closed by the shoulder to form a cooling channel.